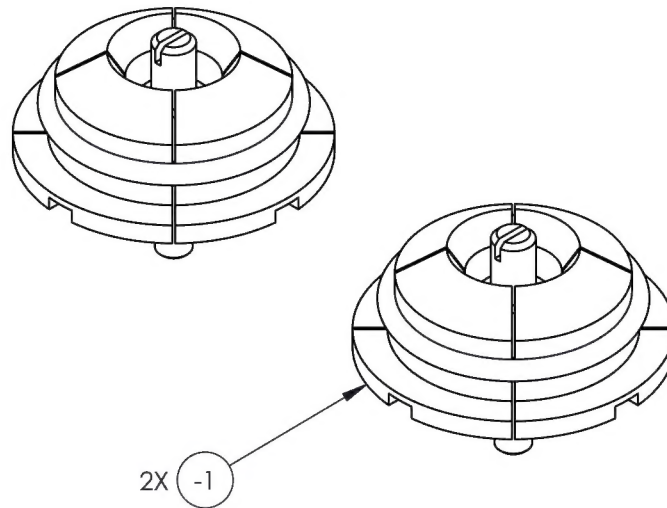


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION	5/24/2016	DPD	JAG



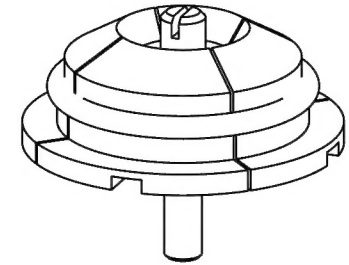
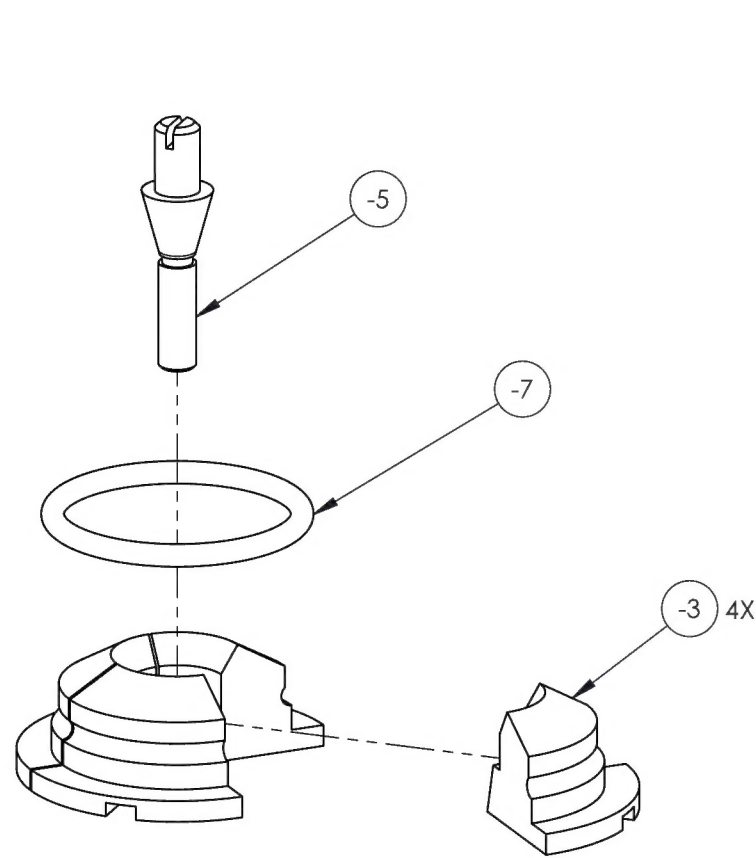
NOTE:  
REF. EUROCOPTER T/N: 105-41069W3.

<b>DART AEROSPACE</b>																	
TITLE <b>STAKING TOOL</b>																	
DWG NO. <b>RBE105-41069W3</b>	REV <b>1</b>																
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td></td> <td>.XX ± .01 ANGLES ± .5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125✓</td> </tr> <tr> <td>SPEC</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td></td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td></td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8		.XX ± .01 ANGLES ± .5°		.X ± .1 SURFACES = 125✓	SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		2. DIMENSIONAL LIMITS APPLY AFTER PLATING		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
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APPROVED:	GILBERT																
<table border="1"> <tr> <td>SCALE</td> <td>1:1</td> </tr> <tr> <td>DATE</td> <td>1/19/2016</td> </tr> <tr> <td colspan="2">SHEET 1 OF 4</td> </tr> </table>		SCALE	1:1	DATE	1/19/2016	SHEET 1 OF 4											
SCALE	1:1																
DATE	1/19/2016																
SHEET 1 OF 4																	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	STAKING TOOL ASSEMBLY			2
	4		-3		STAKING INSERT	4140/4142		3
	1		-5		POSITIONING SCREW	4140/4142		4
	1	B/O	-7		O-RING	BUNA-N	Ø3mm X 30mm I.D. (MCMASTER-CARR #1174N608)	2
	ASSY -1							

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

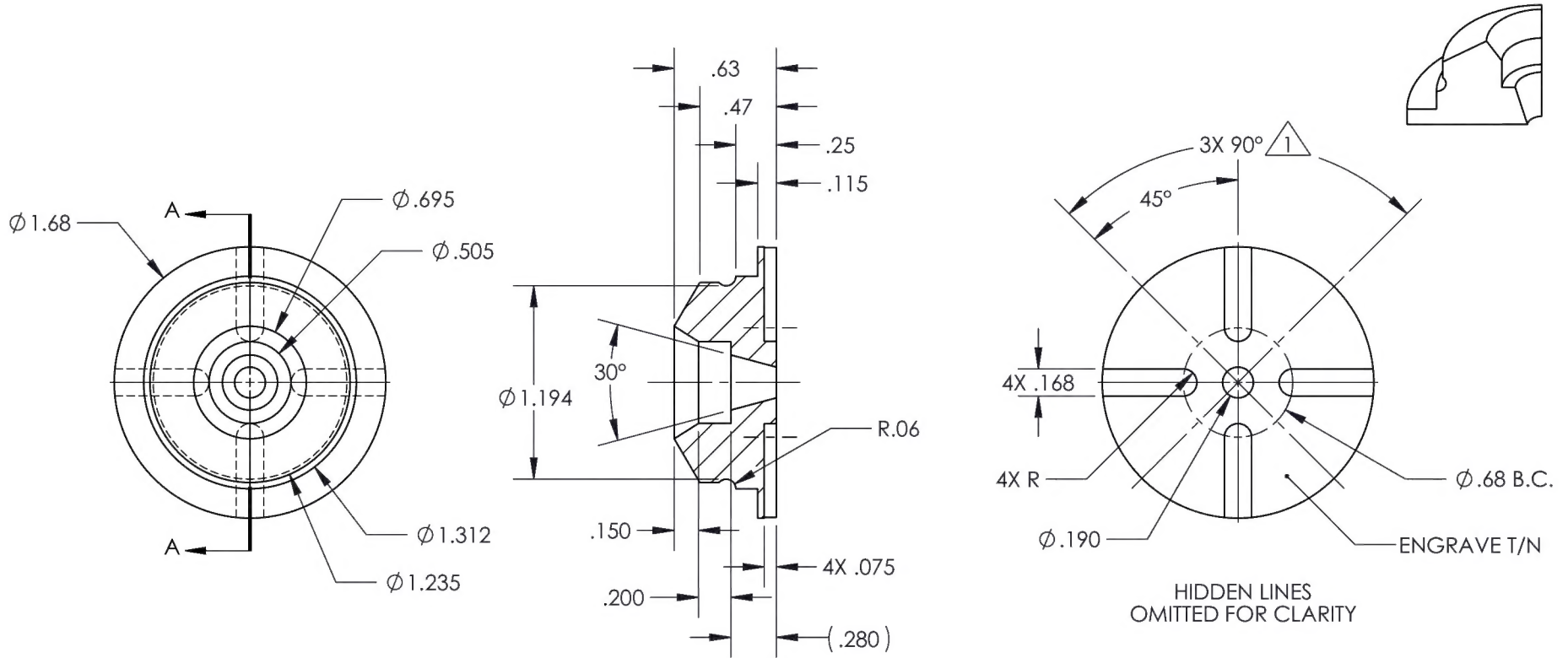


(-1)  
STAKING TOOL ASSEMBLY

<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL</b>	
DWG NO. <b>RBE105-41069W3-1</b>	REV <b>1</b>
MAT'L TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: <b>DUERFELDT</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: <b>CLOUGH</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: <b>ANDERSON</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: <b>LINDSAY</b>	USED ON MODEL
APPROVED: <b>GILBERT</b>	<b>EC145</b>
SCALE <b>1:1</b>	DATE <b>1/19/2016</b>
SHEET 2 OF 4	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION A-A

NOTE:

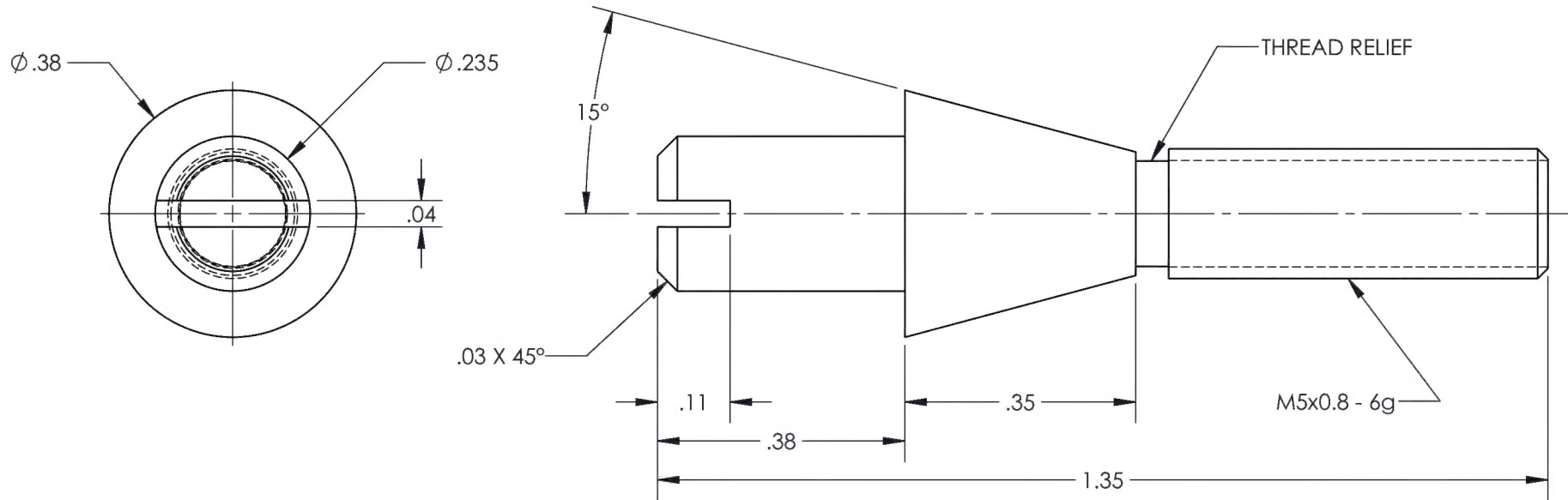
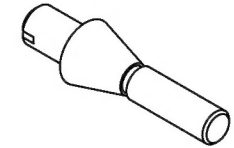
1 EDM TO SPLIT INTO 4 EQUAL PIECES.

(-3)  
STAKING INSERT

<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL</b>	
DWG NO. <b>RBE105-41069W3-3</b>	REV <b>1</b>
MAT'L 4140/4142 HEAT TREAT RC 50-55 FINISH ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:1	DATE 1/19/2016
SHEET 3 OF 4	

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				APPROVED



(-5)

POSITIONING SCREW

<b>DART AEROSPACE</b>	
TITLE: STAKING TOOL	
DWG NO. RBE105-41069W3-5	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
TREAT RC 48-55	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
SPEC ASTM B633 TYPE I SC 2	.XX $\pm$ .01 ANGLES $\pm$ 5°
DRAWN BY: DUERFELDT	.X $\pm$ .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 4:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 1/19/2016	USED ON MODEL
	EC145
	SHEET 4 OF 4